

Work Order ID 132967

132967

Page 1

Wednesday, May 20, 2015 11:42:33 AM

Item ID: D412-775-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Protective Trim
 Start Date: 5/20/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 5/20/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: MAY 20 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9503	A								
IIN D412-775	Rev A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-775-013 CHG003								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									

MLJ 15-08-28

ShA
15/9/13

SEP 02 2015

DAG
8
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
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Work Order ID 132967

Wednesday, May 20, 2015 11:42:33 AM

132967

Page 2

Item ID: D412-775-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Protective Trim

Start Date: 5/20/2015 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 5/20/2015 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-775-013								
	Location: <u>026</u>								
	PPP Rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

Smf
15/9/3

DAS
6
8-89

SEP 08 2015

MCS

SEP 08 2015

20150908

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER : ☐																																																																									

Picklist Print

Wednesday, May 20, 2015 11:42:37 AM

Page 1

Work Order ID: 132967

132967

Parent Item: D412-775-013

D412-775-013

Parent Item Name: Step Protective Trim

Start Date: 5/20/2015

Required Date: 5/20/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-10 new issue DD verified by:ec
kit DD 10.02.18 Verified By:EC IPP Rev:B add pick

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3608-1		Manufactured	No			110	Each	9.0000	1	2			

D3608-1

Lower Doubler

Shb

Location

Loc Qty

Loc Code

ST505

9

122733

3

130504

6

DAS

6

9-88

Shb

D3608-3

Manufactured No

110

Each

10.0000

1

2

D3608-3

Upper Doubler

gms

Location

Loc Qty

Loc Code

ST505

10

127544

2

130503

6

131006

2

DAS

6

9-88

Shb

SEP 02 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART SERVICE INSTRUCTION
TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0
REF. TCCA STC SH08-53
REF. FAA STC SR02692NY
REF. EASA STC EASA.IM.R.S.01529

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
NOTICE
WORK ORDER
NO. 132964MUS
15-05-20

SHOP COPY

It has come to Dart's attention that due to variances in airframe, the D3608-1/-3 Lower/Upper Doublers of the D412-775-013 Step Protective Trim Kit at CHG 001 may not always fit as intended. To ensure proper fit, Dart has made changes to both D3608-1/-3 Doublers at CHG 002 and later. The manuals listed above are amended as follows:

IS:

INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A, SECTION 3.2

3.2.5 Locate the D3608-1/-3 Doublers per Figure 3 and 4 and transfer drill #28 ($\phi 0.141$ ") holes from the aircraft to the D3608-1/-3 Doublers. Bend tabs on D3608-1/-3 Doublers as shown in Figure 1 of this service instruction and trim rectangular opening as required to fit airframe.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0, SECTION 53.4

53.4.2 Locate the D3608-1/-3 Doublers per Figure 53-2 and 53-3. If the D3608-1/-3 doublers are being replaced, transfer drill #28 ($\phi 0.141$ ") holes from the aircraft to the D3608-1/-3 Doublers. Bend tabs on D3608-1/-3 Doublers as shown in Figure 1 of this service instruction and trim rectangular opening as required to fit airframe.

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WAS:

INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A, SECTION 3.2

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INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0, SECTION 53.4

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NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

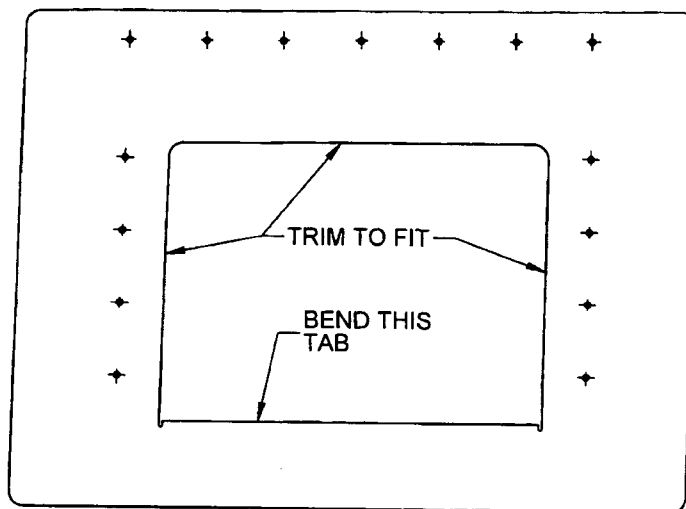
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

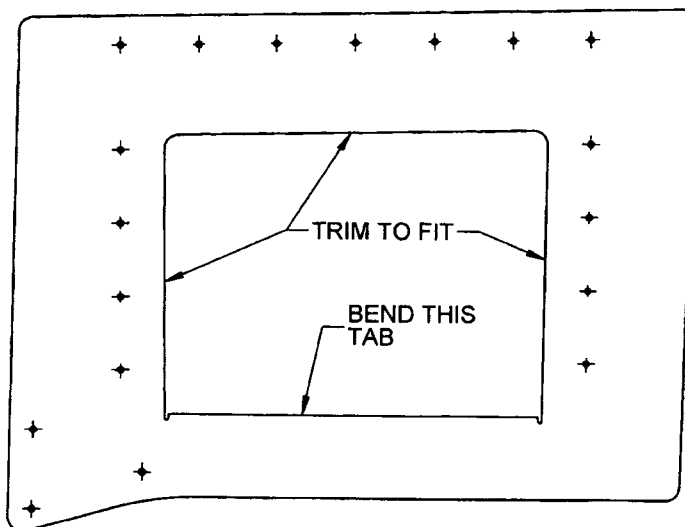
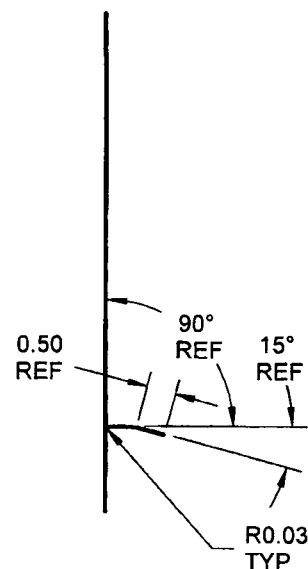
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.02.05
CERT. NO.: SH08-53
ISSUE NO.: 1

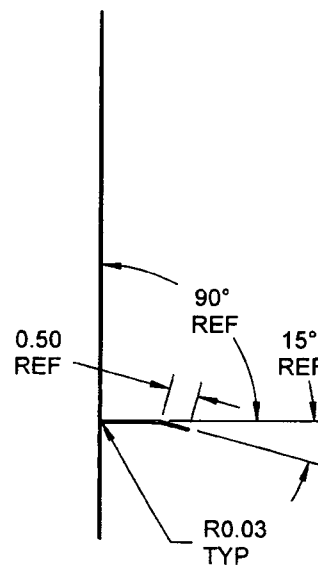
A	NEW ISSUE	MB	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9503	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP PROTECTIVE TRIM CHG	NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3608-3 BENT UPPER DOUBLER



D3608-1 BENT LOWER DOUBLER



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.02.05
CERT. NO.: SH08-53
ISSUE NO.: 1

FIGURE 1: TRIMMING/BENDING OF D3608-1/-3 DOUBLERS
(PARTS SHOWN PRIOR TO TRANSFER DRILLING)

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9503	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP PROTECTIVE TRIM CHG	NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-775-011	DOOR SILL PROTECTIVE TRIM KIT
	X		D412-775-013	STEP PROTECTIVE TRIM KIT
		X	D412-775-015	FUEL PANEL PROTECTIVE TRIM KIT
2			D3602-1	ANGLE
	1		D3608-1	LOWER DOUBLER
	1		D3608-3	UPPER DOUBLER
		1	D3609-1	DOUBLER

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